

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:13:43 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
 Job Number : 32381 REVIEW  
 Estimate Number : 10940  
 P.O. Number : N/A Part Number : D29381  
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2938 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 30480 Material : N/A  
 Due Date : 6/6/2007 Qty: 16 U/m: Each  
 Written By : 4/07.05.16  
 Checked & Approved By : 4/07.05.16  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC  
 Est Rev: C As per Rev C 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003) Batch No: B25349

JL 10/26/07

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

JL / JF 07/25/07

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Sn 07/03/07

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. / En 07/06/07

R/O: 4002 C207100(05)D

2007 8:13:43 AM

History

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW

Part Number: D29381

Job Number: 32381

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

2/20/07/06/09

16

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

15)

07-06-11

16

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

2/10/07/06/02/27/07/06/05/0

P/O 4102

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

2/07/07/03/02

07-07-11

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

2/7/11/59/12

2/7/11/59/12

2/7/11/59/12

2/7/11/59/12

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/07/07/12

Job Completion



2/07/07/12

2/07/07/12

|  |              |             |
|--|--------------|-------------|
| Description: 206 Saddle, Outboard, Left side | Part Number: | D2938-1     |
| Inspection Dwg: D2938 Rev. C                 |              | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.100 | 0.140 |                | .116                       | .116  | .117  | .118  |    |      |
| B             | 0.100 | 0.140 |                | .114                       | .116  | .117  | .118  |    |      |
| C             | 0.100 | 0.140 |                | .118                       | .118  | .118  | .118  |    |      |
| D             | 0.210 | 0.230 |                | .224                       | .222  | .221  | .222  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.499 | 2.500 | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | 0.511                      | 0.511 | 0.511 | 0.511 |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| K             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259  |    |      |
| L             | 0.312 | 0.317 |                | .315                       | .315  | .315  | .315  |    |      |
| M             | 0.235 | 0.240 |                | 0.239                      | 0.239 | 0.239 | 0.239 |    |      |
| N             | 0.100 | 0.140 |                | .121                       | .121  | .121  | .120  |    |      |
| O             | 0.540 | 0.560 |                | .550                       | .551  | .550  | .549  |    |      |
| P             | 0.490 | 0.510 |                | .499                       | .498  | .498  | .501  |    |      |
| Q             | 3.715 | 3.725 |                | 3.719                      | 3.719 | 3.719 | 3.719 |    |      |
| R             | 2.720 | 2.760 |                | 2.740                      | 2.740 | 2.740 | 2.740 |    |      |
| S             | 0.240 | 0.270 |                | .250                       | .250  | .251  | .252  |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |    |      |
| W             | 0.316 | 0.321 |                | .320                       | .320  | .320  | .320  |    |      |
| X             | 1.250 | 1.270 |                | 1.260                      | 1.263 | 1.260 | 1.261 |    |      |
| Y             | 1.565 | 1.585 |                | 1.572                      | 1.575 | 1.573 | 1.573 |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

Measured by: JD  
Date: 07/05/22 / 07/06/27

Audited by: QW  
Date: 07/06/29

| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                   | KJ/JLM     |          |

|   |                             |
|---|-----------------------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b> 32381    |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> D2938-1 |
| <b>Inspection Dwg:</b> D2938 Rev. C                 | <b>Page 1 of 1</b>          |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|--------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4      |    |      |
| A             | 0.100 | 0.140 |                | .119                       | .119  | .118  | .119"  |    |      |
| B             | 0.100 | 0.140 |                | .118                       | .119  | .118  | .119"  |    |      |
| C             | 0.100 | 0.140 |                | .119                       | .119  | .119  | .125"  |    |      |
| D             | 0.210 | 0.230 |                | .222                       | .220  | .220  | .225"  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.252" |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250" |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.502" |    |      |
| H             | 0.510 | 0.515 |                | 0.511                      | 0.511 | 0.511 | 0.511" |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.580" |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500" |    |      |
| K             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259"  |    |      |
| L             | 0.312 | 0.317 |                | .315                       | .315  | .315  | .315"  |    |      |
| M             | 0.235 | 0.240 |                | 0.237                      | 0.237 | 0.237 | 0.237" |    |      |
| N             | 0.100 | 0.140 |                | .123                       | .122  | .122  | .123"  |    |      |
| O             | 0.540 | 0.560 |                | .550                       | .549  | .551  | .551"  |    |      |
| P             | 0.490 | 0.510 |                | .502                       | .498  | .498  | .502"  |    |      |
| Q             | 3.715 | 3.725 |                | 3.719                      | 3.719 | 3.719 | 3.721" |    |      |
| R             | 2.720 | 2.760 |                | 2.740                      | 2.740 | 2.740 | 2.740" |    |      |
| S             | 0.240 | 0.270 |                | .250                       | .251  | .250  | .254"  |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140"  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.631" |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.370" |    |      |
| W             | 0.316 | 0.321 |                | .320                       | .320  | .320  | .320"  |    |      |
| X             | 1.250 | 1.270 |                | 1.265                      | 1.263 | 1.263 | 1.263" |    |      |
| Y             | 1.565 | 1.585 |                | 1.577                      | 1.576 | 1.576 | 1.576" |    |      |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188"  |    |      |
| AA            |       |       |                |                            |       |       |        |    |      |
| AB            |       |       |                |                            |       |       |        |    |      |
| AC            |       |       |                |                            |       |       |        |    |      |
| AD            |       |       |                |                            |       |       |        |    |      |
| AE            |       |       |                |                            |       |       |        |    |      |
| AF            |       |       |                |                            |       |       |        |    |      |
| AG            |       |       |                |                            |       |       |        |    |      |
| AH            |       |       |                |                            |       |       |        |    |      |
| Accept/Reject |       |       |                |                            |       |       |        |    |      |

|                                 |                  |
|---------------------------------|------------------|
| Measured by: J.L. / J.F. / J.M. | Audited by: J.M. |
| Date: 07/05/23 / 07/06/09       | Date: 07/06/09   |

| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                   | KJ/JLM     |          |

|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 32381       |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2938-1     |
| <b>Inspection Dwg:</b> D2938 Rev. C                 |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |        |        |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2      | 3      | 4      |    |      |
| A             | 0.100 | 0.140 |                | .119"                      | .119"  | .117"  | .118"  |    |      |
| B             | 0.100 | 0.140 |                | .120"                      | .122"  | .121"  | .121"  |    |      |
| C             | 0.100 | 0.140 |                | .126"                      | .127"  | .125"  | .126"  |    |      |
| D             | 0.210 | 0.230 |                | .224"                      | .225"  | .225"  | .225"  |    |      |
| E             | 1.245 | 1.255 |                | 1.250"                     | 1.250" | 1.252" | 1.251" |    |      |
| F             | 1.245 | 1.255 |                | 1.250"                     | 1.250" | 1.251" | 1.252" |    |      |
| G             | 2.495 | 2.505 |                | 2.501"                     | 2.501" | 2.503" | 2.503" |    |      |
| H             | 0.510 | 0.515 |                | 0.511"                     | 0.511" | 0.511" | 0.511" |    |      |
| I             | 1.572 | 1.582 |                | 1.581"                     | 1.581" | 1.581" | 1.580" |    |      |
| J             | 2.495 | 2.505 |                | 2.501"                     | 2.503" | 2.503" | 2.501" |    |      |
| K             | 0.257 | 0.262 |                | 0.258"                     | 0.258" | 0.258" | 0.258" |    |      |
| L             | 0.312 | 0.317 |                | 0.313"                     | 0.313" | 0.313" | 0.313" |    |      |
| M             | 0.235 | 0.240 |                | 0.231"                     | 0.231" | 0.231" | 0.231" |    |      |
| N             | 0.100 | 0.140 |                | .123"                      | .123"  | .123"  | .123"  |    |      |
| O             | 0.540 | 0.560 |                | .550"                      | .551"  | .552"  | .550"  |    |      |
| P             | 0.490 | 0.510 |                | .504"                      | .504"  | .507"  | .505"  |    |      |
| Q             | 3.715 | 3.725 |                | 3.718"                     | 3.722" | 3.722" | 3.724" |    |      |
| R             | 2.720 | 2.760 |                | 2.740"                     | 2.740" | 2.740" | 2.740" |    |      |
| S             | 0.240 | 0.270 |                | .253"                      | .258"  | .254"  | .254"  |    |      |
| T             | 0.100 | 0.180 |                | .140"                      | .140"  | .140"  | .140"  |    |      |
| U             | 1.625 | 1.635 |                | 1.632"                     | 1.632" | 1.633" | 1.632" |    |      |
| V             | 1.362 | 1.372 |                | 1.370"                     | 1.371" | 1.369" | 1.369" |    |      |
| W             | 0.316 | 0.321 |                | 0.319"                     | 0.319" | 0.319" | 0.319" |    |      |
| X             | 1.250 | 1.270 |                | 1.262"                     | 1.259" | 1.261" | 1.261" |    |      |
| Y             | 1.565 | 1.585 |                | 1.576"                     | 1.572" | 1.575" | 1.575" |    |      |
| Z             | 0.178 | 0.198 |                | A.188"                     | A.188" | A.188" | A.188" |    |      |
| AA            |       |       |                |                            |        |        |        |    |      |
| AB            |       |       |                |                            |        |        |        |    |      |
| AC            |       |       |                |                            |        |        |        |    |      |
| AD            |       |       |                |                            |        |        |        |    |      |
| AE            |       |       |                |                            |        |        |        |    |      |
| AF            |       |       |                |                            |        |        |        |    |      |
| AG            |       |       |                |                            |        |        |        |    |      |
| AH            |       |       |                |                            |        |        |        |    |      |
| Accept/Reject |       |       |                |                            |        |        |        |    |      |

|                           |                         |
|---------------------------|-------------------------|
| Measured by: J.F.         | Audited by: [Signature] |
| Date: 07/05/24 / 07/06/07 | Date: 07/06/09          |

| Rev | Date     | Change   | Revised by | Approved    |
|-----|----------|--|------------|-------------|
| A   |          | New Issue  | RF         |             |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |             |
| C   | 07.03.21 | Revised per drawing revision C                   | KJ/JLM     | [Signature] |

|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 32381       |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2938-1     |
| <b>Inspection Dwg:</b> D2938 Rev. C                 |                     | Page 1 of 1 |

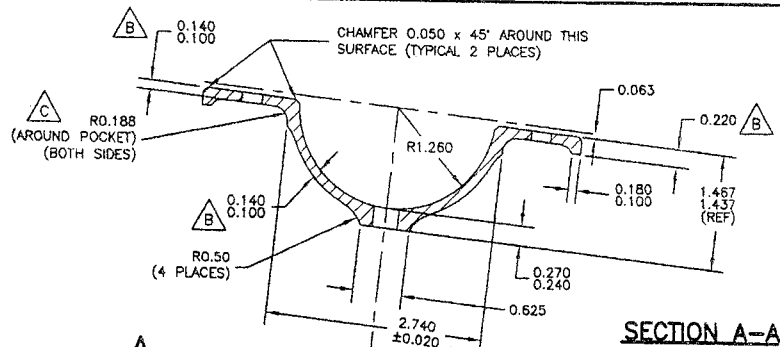
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |        |        |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
|               |       |       |                | 1                          | 2      | 3      | 4      |    |      |
| A             | 0.100 | 0.140 |                | .120"                      | .118"  | .119"  | .119"  |    |      |
| B             | 0.100 | 0.140 |                | .120"                      | .120"  | .122"  | .122"  |    |      |
| C             | 0.100 | 0.140 |                | .126"                      | .126"  | .126"  | .126"  |    |      |
| D             | 0.210 | 0.230 |                | .234"                      | .236"  | .226"  | .226"  |    |      |
| E             | 1.245 | 1.255 |                | 1.250"                     | 1.250" | 1.250" | 1.250" |    |      |
| F             | 1.245 | 1.255 |                | 1.251"                     | 1.250" | 1.250" | 1.250" |    |      |
| G             | 2.495 | 2.505 |                | 2.502"                     | 2.501" | 2.501" | 2.501" |    |      |
| H             | 0.510 | 0.515 |                | 0.511"                     | 0.511" | 0.511" | 0.511" |    |      |
| I             | 1.572 | 1.582 |                | 1.582"                     | 1.580" | 1.580" | 1.580" |    |      |
| J             | 2.495 | 2.505 |                | 2.503"                     | 2.501" | 2.501" | 2.501" |    |      |
| K             | 0.257 | 0.262 |                | 0.258"                     | 0.258" | 0.258" | 0.258" |    |      |
| L             | 0.312 | 0.317 |                | 0.313"                     | 0.313" | 0.313" | 0.313" |    |      |
| M             | 0.235 | 0.240 |                | 0.239"                     | 0.239" | 0.239" | 0.239" |    |      |
| N             | 0.100 | 0.140 |                | .124"                      | .123"  | .123"  | .123"  |    |      |
| O             | 0.540 | 0.560 |                | .550"                      | .551"  | .550"  | .549"  |    |      |
| P             | 0.490 | 0.510 |                | .502"                      | .504"  | .502"  | .502"  |    |      |
| Q             | 3.715 | 3.725 |                | 3.721"                     | 3.722" | 3.722" | 3.722" |    |      |
| R             | 2.720 | 2.760 |                | 2.740"                     | 2.740" | 2.740" | 2.740" |    |      |
| S             | 0.240 | 0.270 |                | .254"                      | .255"  | .255"  | .255"  |    |      |
| T             | 0.100 | 0.180 |                | .140"                      | .140"  | .140"  | .140"  |    |      |
| U             | 1.625 | 1.635 |                | 1.633"                     | 1.633" | 1.633" | 1.633" |    |      |
| V             | 1.362 | 1.372 |                | 1.370"                     | 1.369" | 1.369" | 1.369" |    |      |
| W             | 0.316 | 0.321 |                | 0.319"                     | 0.319" | 0.319" | 0.319" |    |      |
| X             | 1.250 | 1.270 |                | 1.262"                     | 1.262" | 1.261" | 1.261" |    |      |
| Y             | 1.565 | 1.585 |                | 1.575"                     | 1.576" | 1.575" | 1.575" |    |      |
| Z             | 0.178 | 0.198 |                | .188"                      | .188"  | .188"  | .188"  |    |      |
| AA            |       |       |                |                            |        |        |        |    |      |
| AB            |       |       |                |                            |        |        |        |    |      |
| AC            |       |       |                |                            |        |        |        |    |      |
| AD            |       |       |                |                            |        |        |        |    |      |
| AE            |       |       |                |                            |        |        |        |    |      |
| AF            |       |       |                |                            |        |        |        |    |      |
| AG            |       |       |                |                            |        |        |        |    |      |
| AH            |       |       |                |                            |        |        |        |    |      |
| Accept/Reject |       |       |                |                            |        |        |        |    |      |

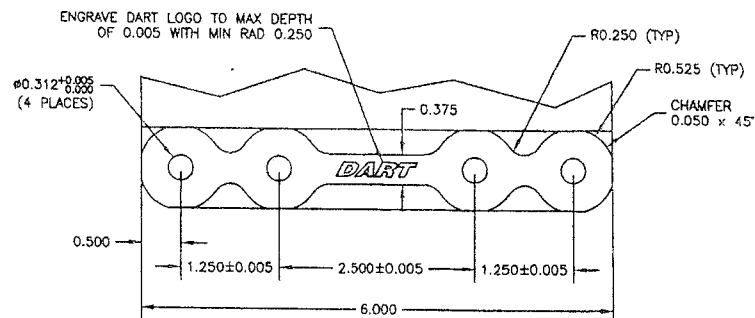
Measured by: J.F.  
Date: 07/05/24 / 07/06/07

Audited by: J.F.  
Date: 07/06/09

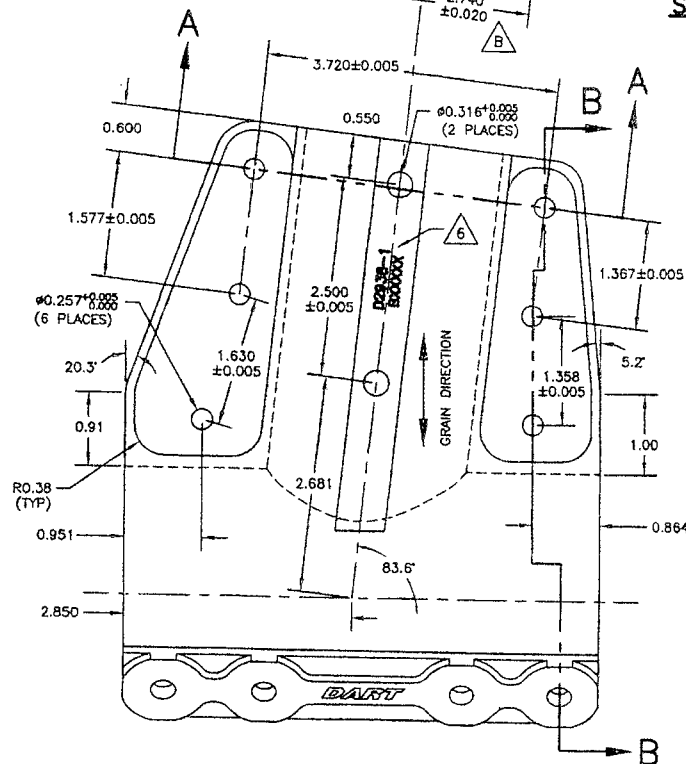
| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |
| C   | 07.03.21 | Revised per drawing revision C                   | KJ/JLM     |          |



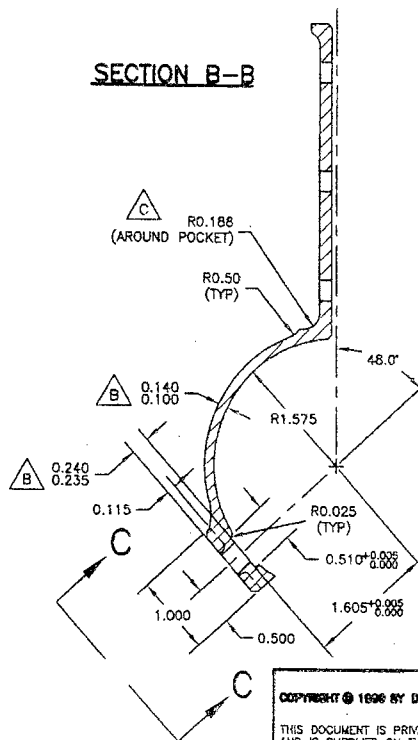
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

|         |          |   |
|---------|----------|---|
| C       | 06.11.09 | R0.188 WAS R0.30 TO R0.25                       |
| B       | 00.05.29 | CHANGED GEOMETRY AND MATERIAL                   |
| A       | 99.11.12 | NEW ISSUE                                       |
| DESIGN  | CB       | DART DART AEROSPACE USA, INC.<br>BELLINGHAM, WA |
| CHECKED | PH       | DRAWING NO.<br>D2938                            |
| DATE    | 06.11.09 | TITLE<br>SADDLE OUTSIDE                         |
|         |          | REV. C<br>SHEET 1 OF 1<br>SCALE<br>2:3          |

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07.02.12

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